

Date: Tuesday, 27/01/2009 8:43:25 AM  
 User: Melanie Fauteux

## Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	OUTER TUBE
Job Number :	45258		
Estimate Number :	13501		
P.O. Number :		Part Number :	PB6743001229
This Issue :	27/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	B6743001 P.19
First Issue :	11	Project Number :	N/A
Previous Run :	41489	Drawing Revision :	B1
	Type :	Material :	
	MACHINED PARTS	Due Date :	09/02/2009
Written By :		Qty:	③ Um: Each
Checked & Approved By :	MF 09-01-27		
Comment :	Est Rev:A 08-07-24 new issue DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6T1750W065	6061T6 RDTUBE 1.750 X 0.65W
-----	------------------	-----------------------------



20" Scrap  
 END Pieces



Comment: Qty.: 5.3813 f(s)/Unit Total: 21.5250 f(s)  
 6061T6 RDTUBE 1.750 X 0.65W  
 batch: 110325

8F 09/02/19 ③

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut to length and cut angle on one end of tube as per dwg  
 2- deburr

8F 09/02/19 ③

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE

1- drill holes and mill slot as per dwg PB67-43001  
 2- deburr

8F 09/02/19 ③

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

8 09/03/03 ③

5.0	PB6743001233	Outer Tube Partial End Cap
-----	--------------	----------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)  
 Outer Tube Partial End Cap

B41573

SAD 09-03-03 ③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-229 PAR #: N/A Fault Category: Prod / Machined Parts NCR: Yes No DQA: D Date: 05/03/20  
 Resolution: re-work Disposition: re-work QA: N/C Closed: D Date: 05/03/20

NCR: <u>45258</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/2/25	# 30	# tubes machines too long. 61.625" <del>and</del> shall be 61.500". R.L. Lack of attention (didn't follow Dwg.)		Cut off <del>extra length</del> to size on marked				

NOTE: Date & initial all entries

Date: Tuesday, 27/01/2009 8:43:25 AM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER TUBE

Job Number: 45258

Part Number: PB6743001229

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1- bend end cap to fit on tube  
2-Weld end cap as per dwg PB67-43001  
3- grind weld flush

*09-03-17*

*(x3)*

7.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

*Sorter 17 (x3)*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Sorter 17 (x3)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

*09/03/17 (3)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/03/18*

Job Completion



*MF 09-03-17*

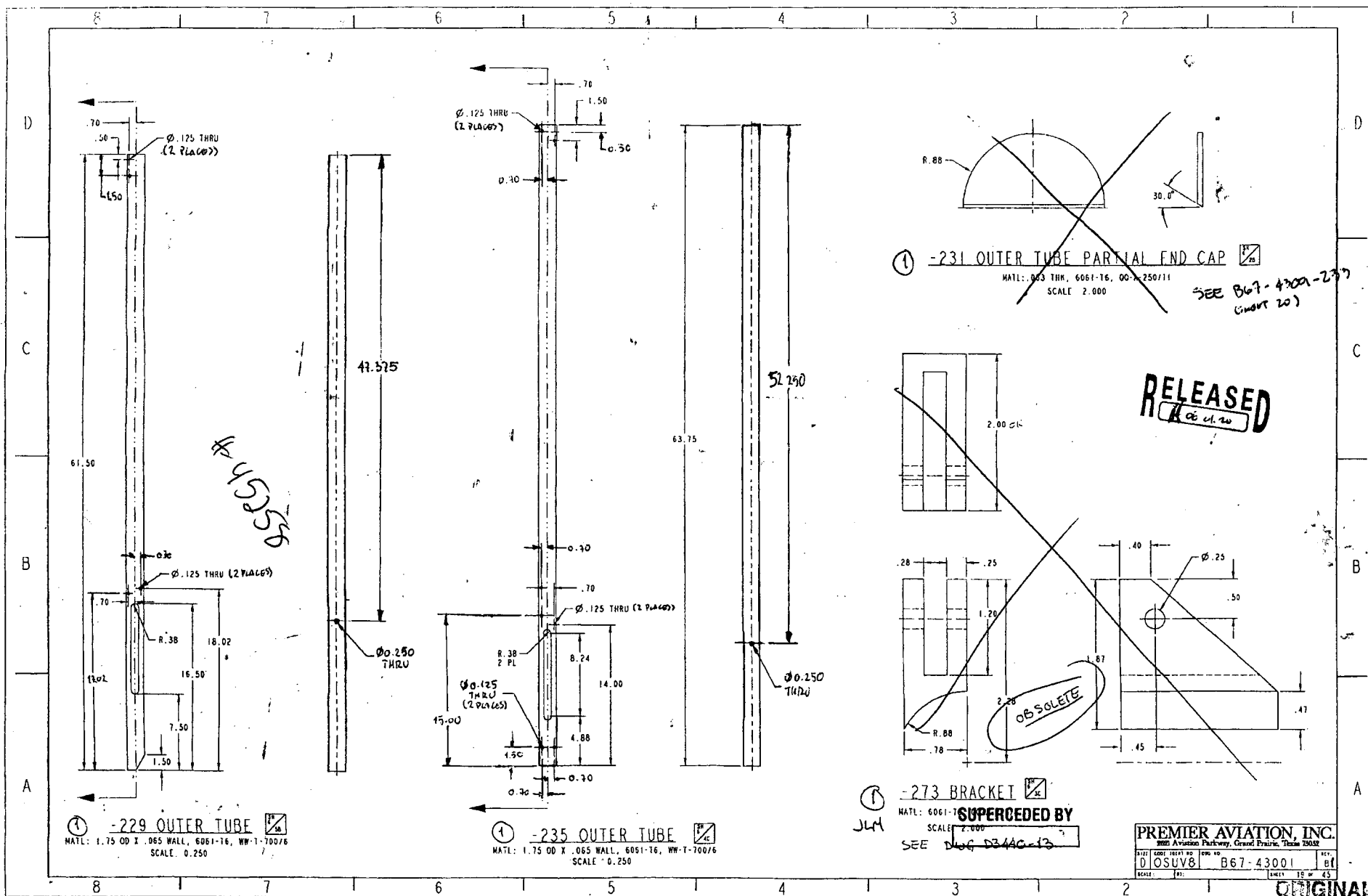
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>PREMIER AVIATION, INC.</b>			
2992 Aviation Parkway, Grand Prairie, Texas 75052			
DATE	CODE	ISSUE NO	OPR NO
D	OSUV8		B67-43001
SCALE :	BY :	SHEET	OF 45

**ORIGINAL**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries